

Work Order ID 134833

Tuesday, July 21, 2015 2:45:20 PM

134833

Page 1

Item ID: D2654-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Web
Start Date: 7/21/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/21/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: MLS Date: JUL 21 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2654	F

100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

- 1-Cut D2600-7 to length as per Dwg D2654
2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654
3-Using the uni-bit, open holes to finish size as per Dwg D2654
4-Deburr holes and ends

15-727 DGL

110

Chemical Conversion Coat per QSI005 4.1

0.00

110

HandFinish

Memo

0.00

Hand Finishing

4 15-7-29 DGL

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

4 15-07-29

Work Order ID 134833

Tuesday, July 21, 2015 2:45:20 PM

134833

Page 2

Item ID: D2654-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Web
Start Date: 7/21/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/21/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>40002</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

④ 1507-29 PD
4 0 15-7-29 DGL
15/7/30 JH
mf 15-7-29

Picklist Print

Tuesday, July 21, 2015 2:45:24 PM

Page 1

Work Order ID: 134833

134833

Parent Item: D2654-7

D2654-7

Parent Item Name: Web

Start Date: 7/21/2015

Required Date: 7/21/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedureDM
IPP Rev:e 06.04.05 Added level21 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-7-140		Manufactured	No			100	Each	67.0000	1	4			

D2600-7-140

EXT. "I BEAM" THICK

Location

Loc Qty

Loc Code

LG

67

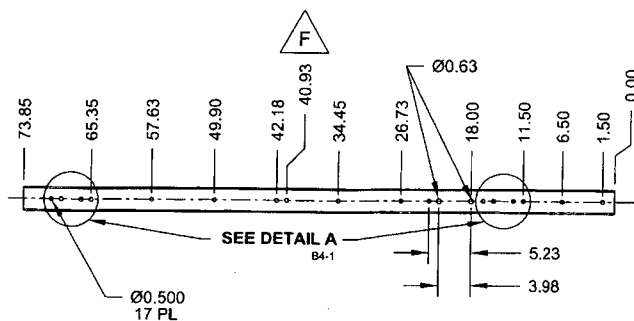
67

131525

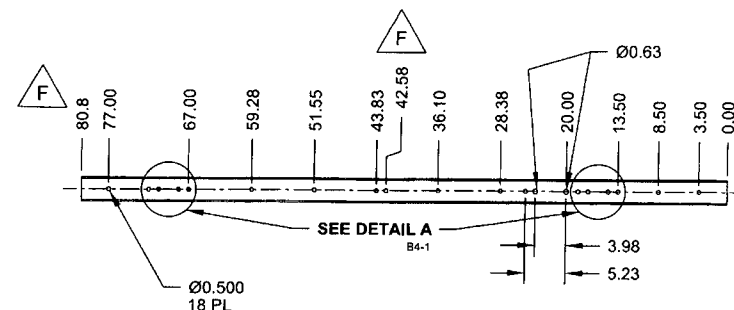
(L)

DGC

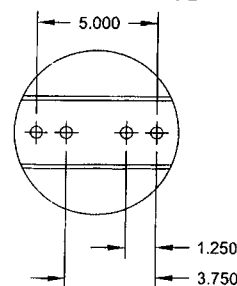
15-7-27



D2654-1 WEB



D2654-3 WEB



DETAIL A

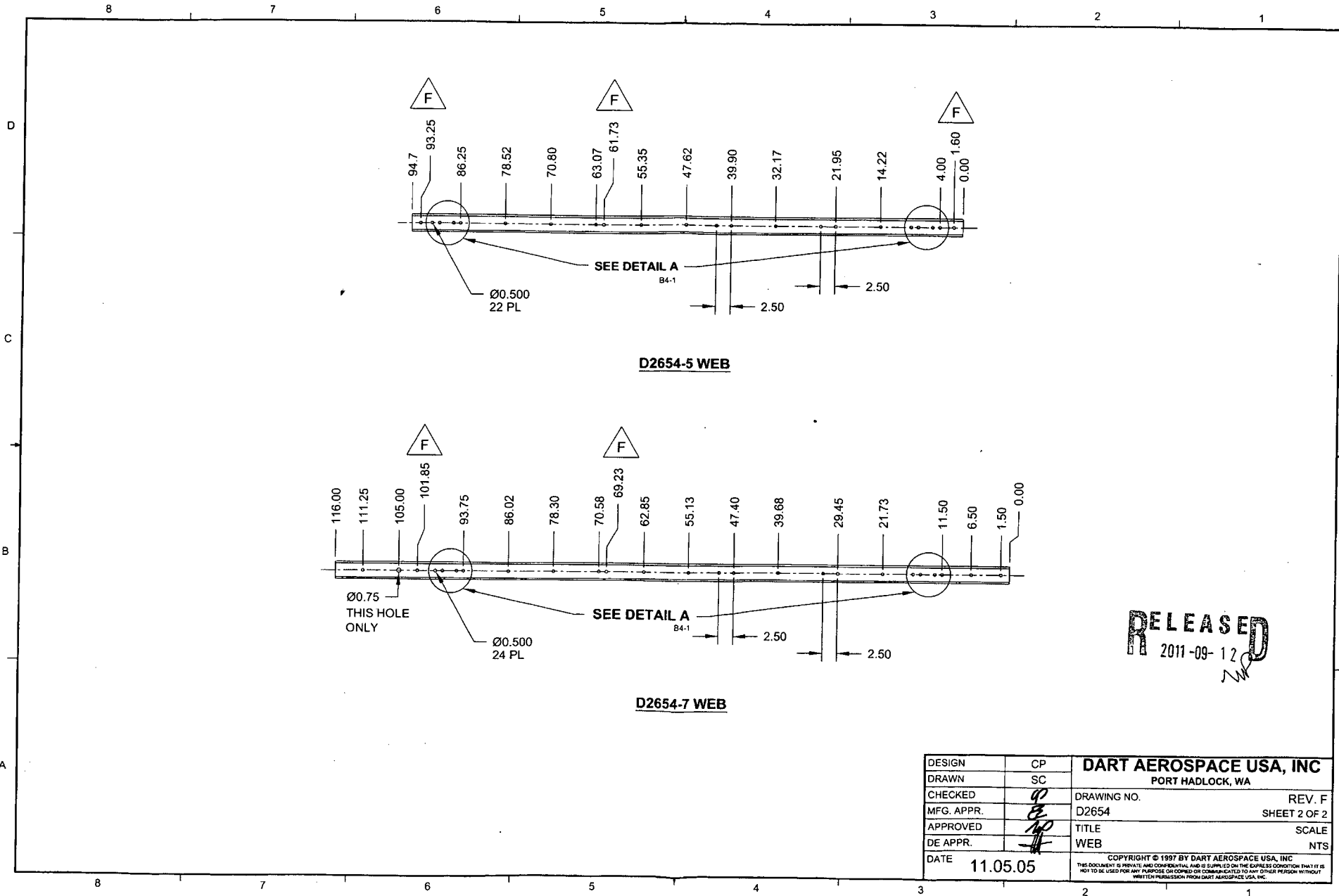
C2-1
C3-1
C6-1
C8-1
D3-2
D6-2
B3-2
B6-2

NOTES:

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

RELEASED
2011-09-12
W

REV.	DESCRIPTION	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHW HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25
DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	W	DRAWING NO.	REV. F
MFG. APPR.	E	D2654	SHEET 1 OF 2
APPROVED	W	TITLE	SCALE
DE APPR.	W	WEB	NTS
DATE	11.05.05	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



RELEASED
2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. F
MFG. APPR.	JP	D2654	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEB	NTS
DATE	11.05.05	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	